

Rush ship 30-31/03

Work Order ID 67670

Tuesday, March 29, 2011 10:57:42 AM



Page 1

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/29/2011 **Start Qty:** 1.00



Cust Item ID:

Required Date: 3/30/2011 **Req'd Qty:** 1.00



Customer:

Reference:

Approvals: **Process Plan:**

✓

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

Draw Nbr

Revision Nbr

D3195

Rev A

100



BAND SAW

0.00

✓ 11/03/28

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blanks: (1.250" x 1.500") x 3.60" long

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3112-Deburr

✓ 11/03/28

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

✓ 11/03/28

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Start Date: 3/29/2011 Start Qty: 1.00



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Required Date: 3/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130

QC8- Inspect parts - second check



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

0.00

Mar 11/03/30

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

1 BL 11-3-30.

Memo

0.00

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 15128.

Memo

0.00

START TIME: 10:30 OVEN TEMPERATURE:
320° FINISH TIME: 11:00

1 BL 11-3-30.

Work Order ID 67670

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Item ID: D3195-043

Accept



Setup Start



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Stop



Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

QC3- Inspect Part Finish

0.00

1 0

3/30/2010

Quality Control

170



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Lightly Sand bonding surface 12-Bond D3195-7 into D3195-13as per Dwg
D3195-1A/RContact Cement 3/30/2010

3/30/2010

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

3/30/2010

40

Work Order ID 67670

Tuesday, March 29, 2011 10:57:42 AM



Page 4

Item ID: D3195-043

Accept



Setup

Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

190



Packaging

Memo

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Identify as per dwg & Stock Location: *Stage A*

0.00

0.00

Mar 30 0

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/30 20
11/03/30

Picklist Print

Tuesday, March 29, 2011 10:57:39 AM

Page 1

Work Order ID: 67670



Parent Item: D3195-043



Parent Item Name: Bracket Assembly

Start Date: 3/29/2011

Required Date: 3/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-7 		Manufactured	No			100	Each	8.0000	1	1			<i>3/29/103/30</i>

Pad

Location	Loc Qty	Loc Code
GA	8	
51569	4	
64534	4	

M6061T6B1.500X01.25
0



6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code
MAT004	15.8	
107461	0.9	
110936	14.9	

133 f

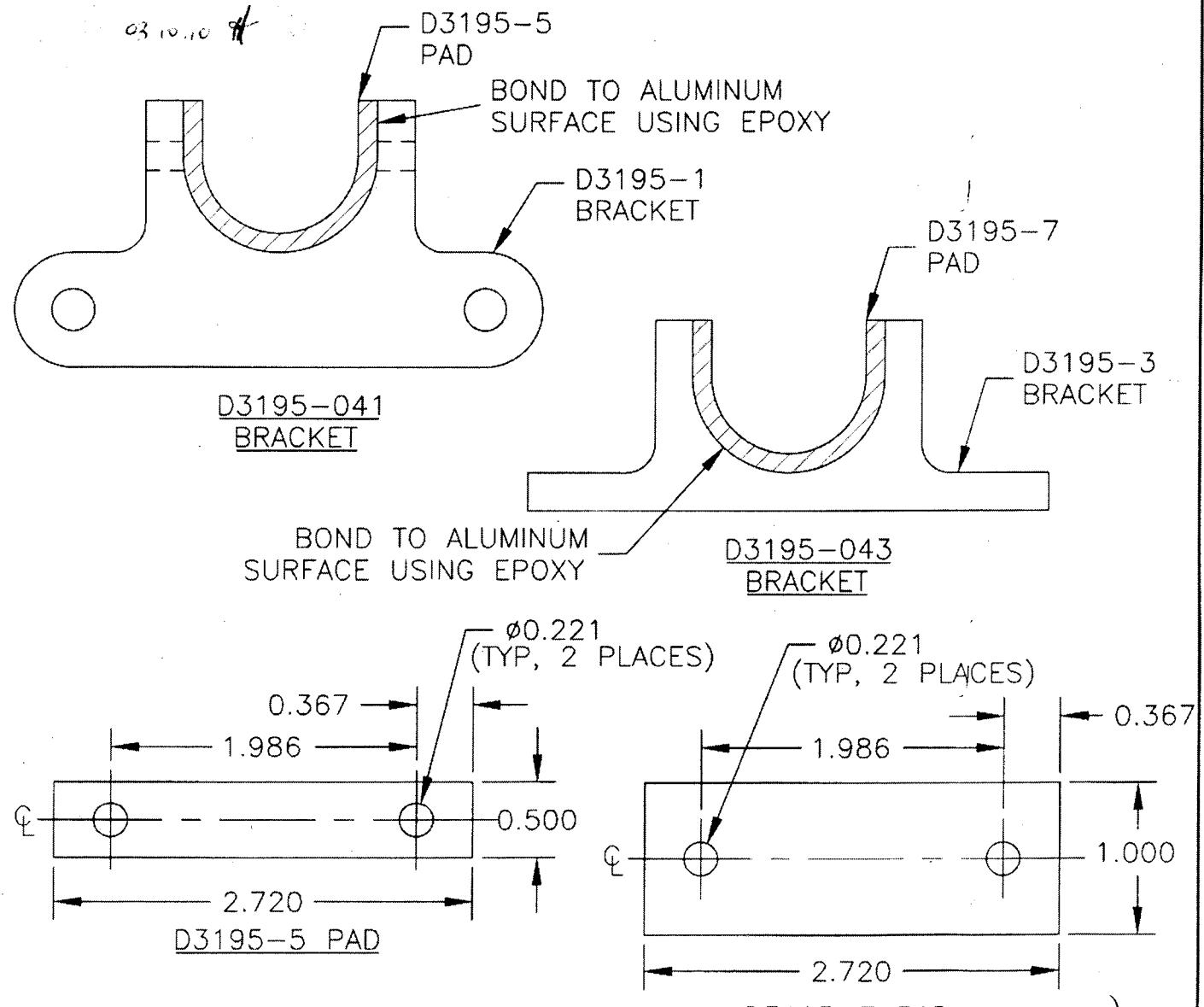
80 11/03/28



1 COPY IS
MADE
HERE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3195
DATE		REV. A SHEET 1 OF 3
03.06.23		TITLE BRACKET
A	03.06.23	SCALE 1:1 NEW ISSUE

03.06.23



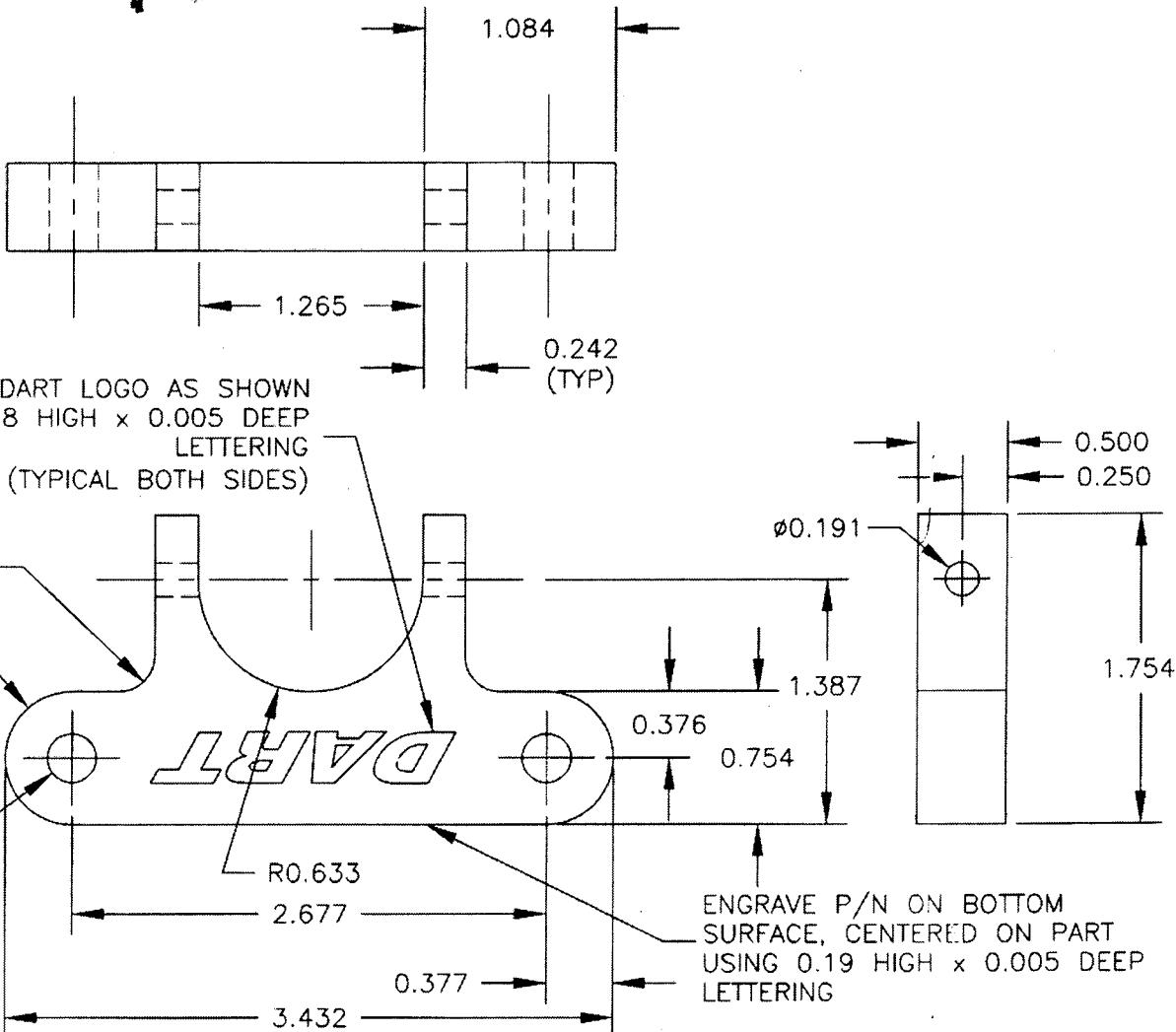
D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

W067670



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D3195
DATE	03.06.23			REV. A SHEET 2 OF 3 TITLE BRACKET SCALE 1:1



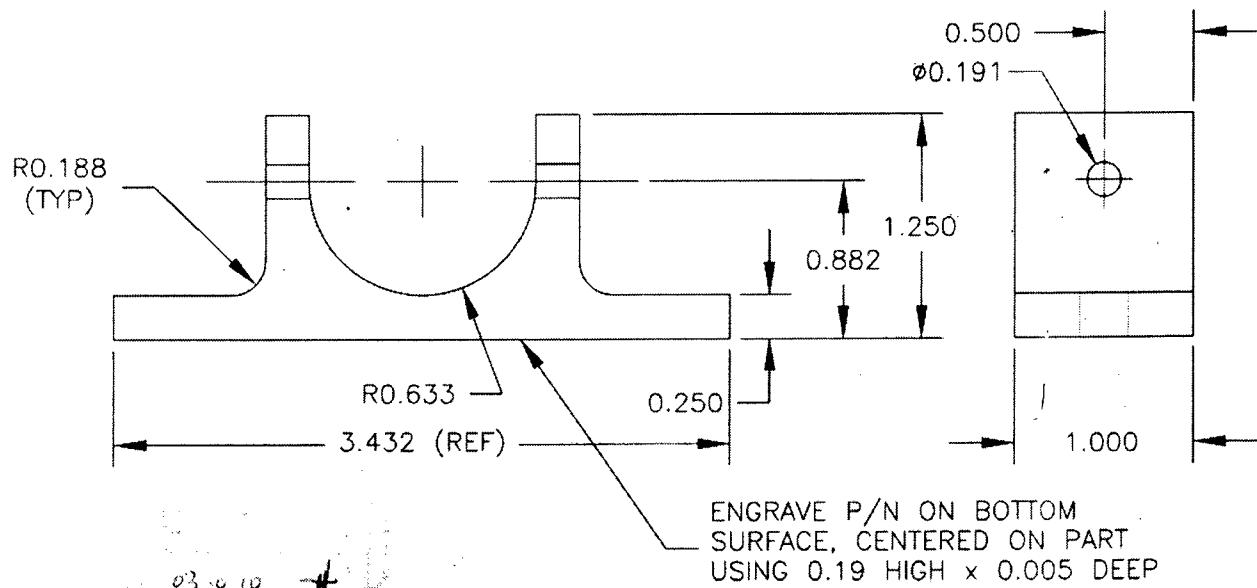
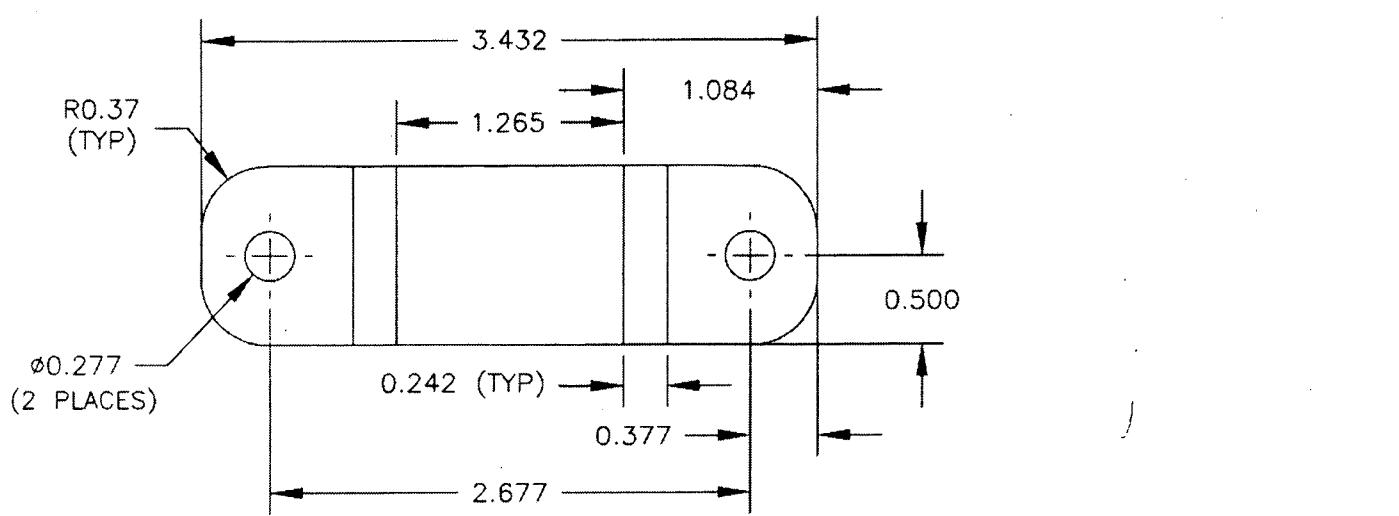
D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

67690



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3195
DATE	TITLE	REV. A SHEET 3 OF 3 SCALE 1:1



D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

6/6/03

DART AEROSPACE LTD	Work Order:	67670
Description: Bracket	Part Number:	3195-3
Inspection Dwg: 3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	11/03/30	Date:	11/03/30	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	